

Work Order ID 68067

Wednesday, April 06, 2011 8:27:57 AM

Page 1

Item ID: D4380-37

Accept

Setup Start

Revision ID: PRELIM

Item Name: Cover, Dimmer Box

Start Date: 4/6/2011 Start Qty: 1.00

Required Date: 4/6/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

PRELIMINARY ISSUE

Approvals:

Process Plan:

Date: 11-04-05

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4380

PA7

A

100

0.00

HandThermo

Memo

0.00

Hand Finishing Thermoforming

I-Cut Sheet to required Blank size

11/04/06

105

0.00

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 Kydex

Temp: 150°

Time IN:

6:00 PM 11/04/05

Time OUT:

7:00 AM 11/04/06

11/04/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA128 using tool DT9752

Dwg Rev: PA7

Folio Rev: A

0.00

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

Visually inspect part for proper formation and texture

0.00

130

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

BB
11/04/06BB
11/04/06Wh
11/04/06

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Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

L

DL
11/04/06

150

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

1

B 11/04/06

160

0.00



QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

- inspector to pass

Dunally

8/10/10

W/O:		WORK ORDER CHANGES					
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Page 4

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Setup Start



Revision ID: PRELIM

Stop



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Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: *CAWKE* 0.00

Packaging

Memo

0.00

Packaging

Recall 4/7/11

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

ACTIVE *11/04/06*AUTH *11*SED *11/5/10*DATE *11/05/13**11/5/10**RO2370**11/04/07*

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NOTE: Date & initial all entries

Picklist Print

Wednesday, April 06, 2011 8:27:52 AM

Page 1

Work Order ID: 68067

Parent Item: D4380-37

Parent Item Name: Cover, Dimmer Box



Start Date: 4/6/2011

Required Date: 4/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev. A New Issue, 11/04/06

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No				sf	787.2912		1.735			



6185 KYDEX .080"



Location

Loc Qty

Loc Code

therm

787.2912

116576

787.2912

1.735 ft

OK
11/04/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 68067
Description:	Part Number: #4380-37
Inspection Dwg: D4380 Rev: PA7.	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <i>JB</i>	Date: 11/09/06
-------------------------------	-----------------------

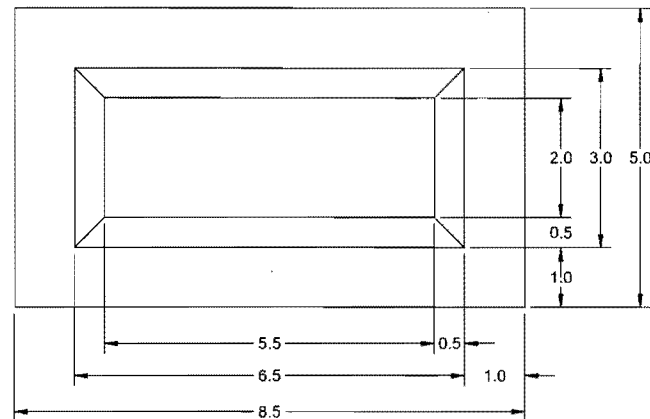
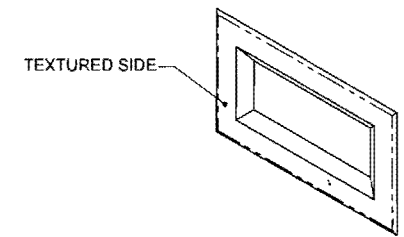
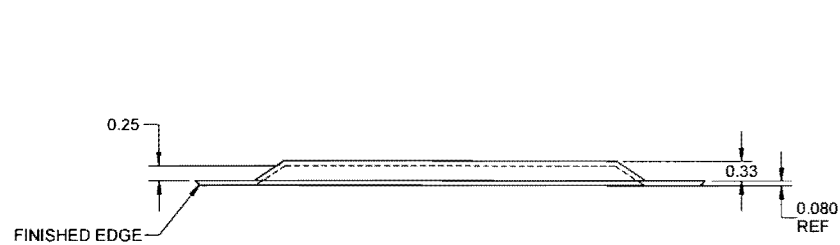
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.5	.100	8.5	✓			
5.0	.100	5.0	✓			
6.5	.100	6.45	✓			
3.0	.100	2.95	✓			

Measured by: <i>JB</i>	Date: 11/09/06
Audited by: <i>S to PA7 Dan vln</i>	Date: 11/09/06
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



#68067

D4380-37 COVER, DIMMER BOX

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.12 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM -37 PART PER MOULD DTXXXX.

PRELIMINARY ISSUE

SC 11.04.05

DESIGN	SC	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA7
MFG. APPR.		D4380	SHEET 18 OF 18
APPROVED		TITLE	SCALE
DE APPR.		CEILING POCKETS	NTS
DATE	11.04.05	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Monday, April 04, 2011 9:16 AM
To: 'Daryl Leger'
Cc: 'JEANLUC MENARD'; Bill Beckett; 'Linda Lacelle'; 'Harvey Siemens'; 'Mike Petsche'
Subject: D4323 & D4380 - Parts can be untrimmed

To Whom It May Concern,

The parts with p/n's D4323-XX and D4380-XX can be shipped to Calgary untrimmed, or even slightly out of spec in order to get parts here asap so they can be installed on the Westpac machine.

Thanks,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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Dart Aerospace Ltd

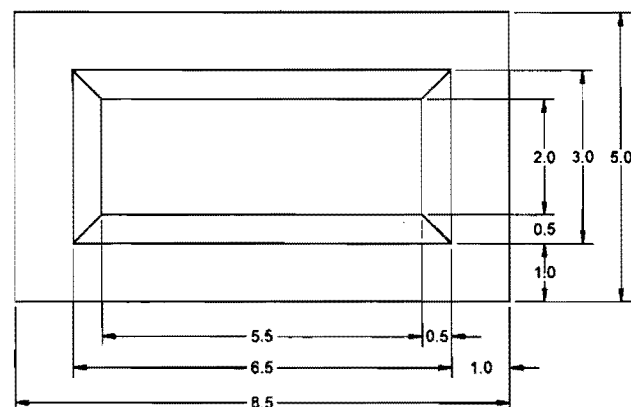
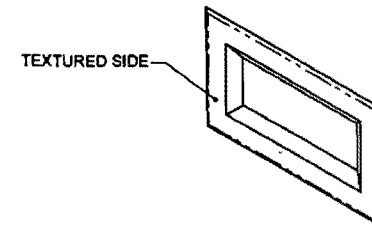
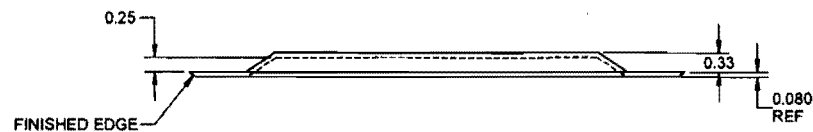
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D4380-37 COVER, DIMMER BOX

68067

RELEASED
2011-05-10

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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.17 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM PER MOULD DT9752 AND DART QSI 022
- 10) TRIM PER MOULD LEAVING FINISHED EDGE
- 11) MAXIMUM INSIDE RADIUS = 0.188

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DC	D4380	SHEET 16 OF 17
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	CEILING POCKETS	NTS
DATE	11.04.21	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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